

Work Order ID 80775

Tuesday, February 28, 2012 3:05:50 PM

80775Ship March 8th
Page 1

Item ID: D3914-041

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Item Name: Long Basket Lid Assembly (350)

Stop ***NS2***

Start Date: 2/28/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/7/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *UMF*Date: *12-02-28* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr Revision Nbr

D3914 B

D4020 A

100 Weld per dwg A/R S.S. rod Batch: *2115778* 0.00***100***

Large Fab

Large Fab

Memo 0.00

1- assemble ribs, weld as per dwg D3914 using DT9607A ✓

2- weld hinge (3) and Mounting brackets as per dwg D3914 ✓

Visual inspect before welding mesh ✓

3- tack weld mesh on basket as per dwg D3914 ✓

Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh ✓

12-02-29 (1x)

110

QC9- Inspect visual per QS1004- Fusion Welds 0.00

110

QC

Quality Control

Memo 0.00

12-03-05 1x ✓

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N900040100

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

130

Powdercoat

Memo

0.00

Powder Coating

*** mask sides of hinge prior to powdercoat***

Start Time: 3:50

Oven Temperature: 3200 F

Finish Time: 4:20

140

Wing Walk as per dwg QSI005 4.4 Batch 12025 0.00

0.00

140

HandFinish

Memo

0.00

Hand Finishing

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label

5/12/05

Ⓢ

1X PM 12/03/06

1 BR 12-2-7

M115128

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Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

1 4 12/07/07

160

Identify as per dwg & Stock Location:

D4030-011

80773.

160

Packaging

Memo

0.00

Packaging

1 BR 123-7

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MLJ 12/03/08

MLJ 12/03/08
(1)

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Picklist Print

Tuesday, February 28, 2012 3:05:49 PM

Page 1

Work Order ID: 80775

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 2/28/2012

Required Date: 3/7/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
10.08.18 verified by:EC

IPP Rev:B as per dwg revB DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2581 Mounting Bracket		Manufactured	No			100	Each	47.0000	2	2		12.02.28	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		47							
				69739		1							
				70766		2							
				77045		15							
				77523		29							
✓ D3914-1 Rib		Manufactured	No			100	Each	4.0000	2	2		B76011 → 2x 12.02.28	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		4							
				77144		1							
				77814		1							
✓ D3914-7 Rib		Manufactured	No			100	Each	6.0000	2	2		12.02.28	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		6							
				78695		2							
				80164		4							
✓ D4016-3 Hinge Half, Lid		Manufactured	No			100	Each	24.0000	3	3		12.02.28	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		24							
				74909		6							
				78495		18							

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Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 2/28/2012

Required Date: 3/7/2012

Start Qty: 1.00

Required Qty: 1.00

D4018-5 Manufactured No 100 Each 2.0000

Rib

Location

Loc Qty

Loc Code

WA005

2

78404

2

D4020-5 Manufactured No 100 Each 3.0000

Mesh (350 Basket Long, Lid)

Location

Loc Qty

Loc Code

WA

3

78698

3

D4021-3 Manufactured No 100 Each 5.0000

Data Plate

Location

Loc Qty

Loc Code

WA005

5

75460

5

D4035-041 Manufactured No 100 Each 5.0000

Lid Rib Assembly, Fwd (350 Basket)

Location

Loc Qty

Loc Code

WA006

5

74642

5

D4035-043 Manufactured No 100 Each 3.0000

Lid Rib Assembly, Aft (350 Basket)

Location

Loc Qty

Loc Code

WA006

3

76545

3

D2728-3 Manufactured No 140 Each 0.0000

Dart Logo label

15050.

9
12.02.28

9x
1
12.02.29

1x
1
12.02.28

1x
1
12.02.28

1x
1
12.02.28

1x
1
12.2.7

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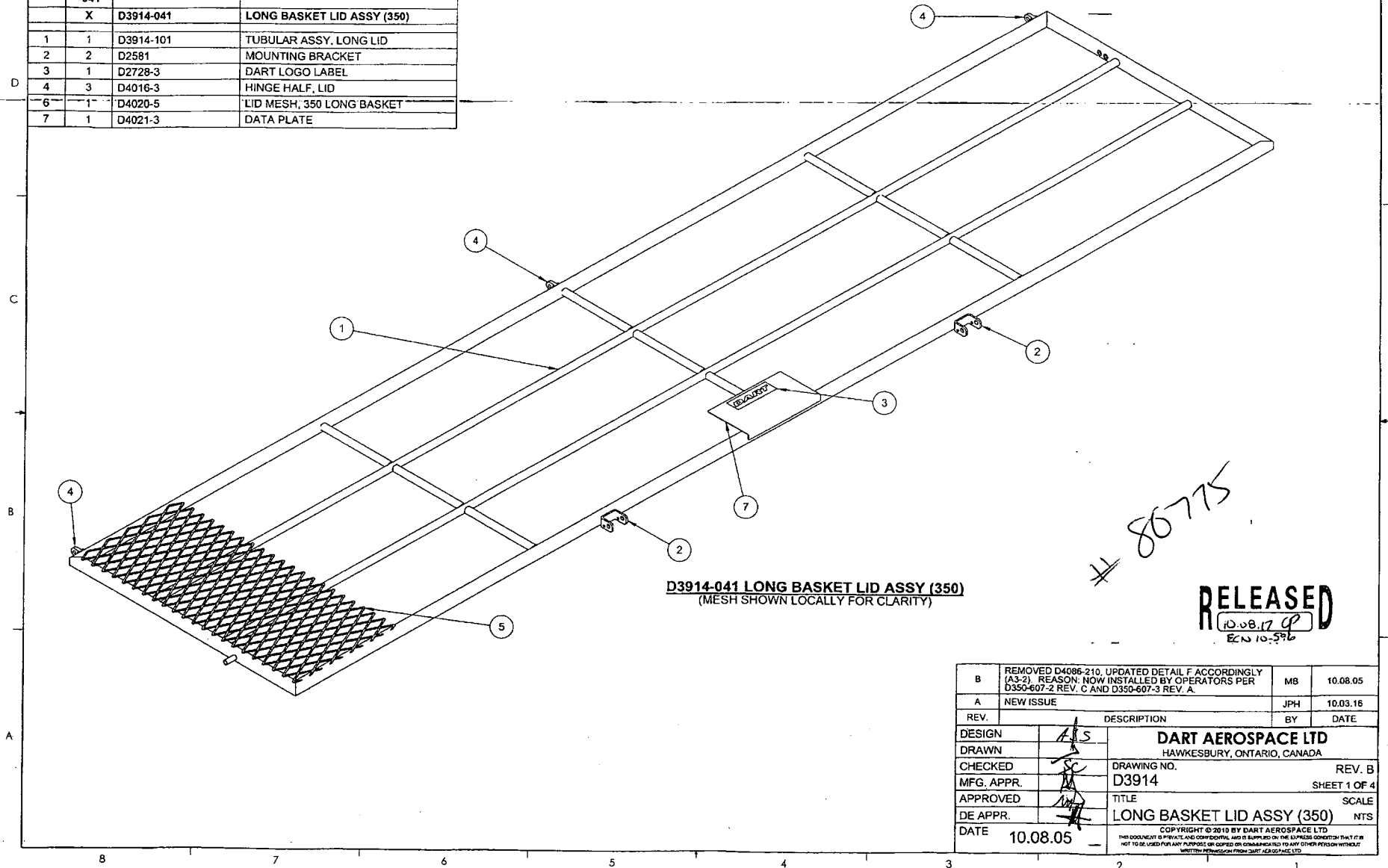
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

B	REMOVED D4886-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO.	REV. B
CHECKED	SC	D3914	SHEET 1 OF 4
MFG. APPR.	10/17	TITLE	SCALE
DE APPR.	10/17	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

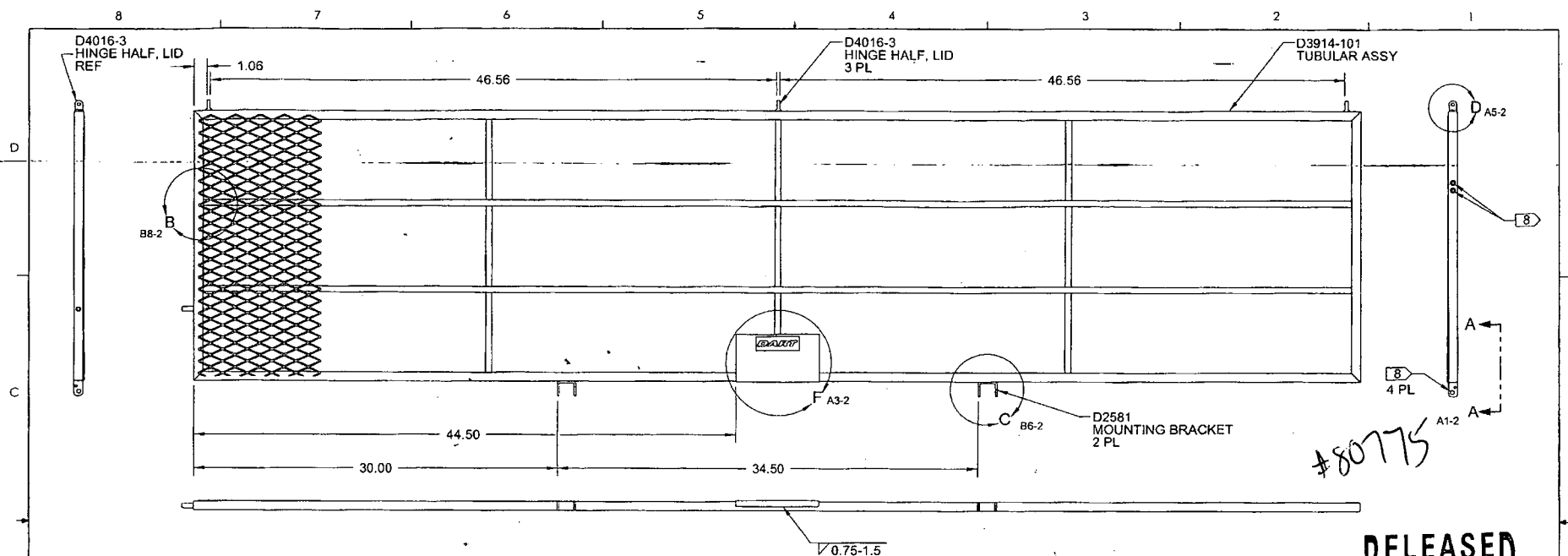
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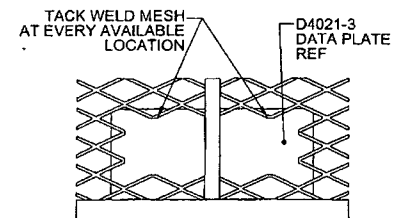
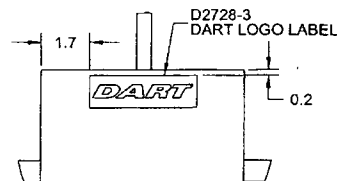
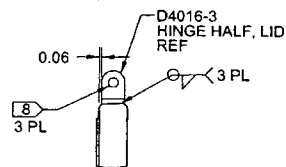
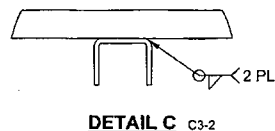
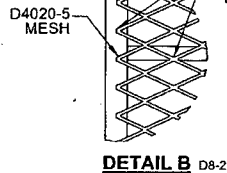
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D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION



- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 22.35 lbs APPROX
 - 8) MASK HOLES PRIOR TO FINISHING
 - 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO. D3914	REV. B
MFG. APPR.		TITLE	SHEET 2 OF 4
APPROVED		LONG BASKET LID ASSY (350)	SCALE
DE APPR.			NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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RELEASED
10-08-12 up

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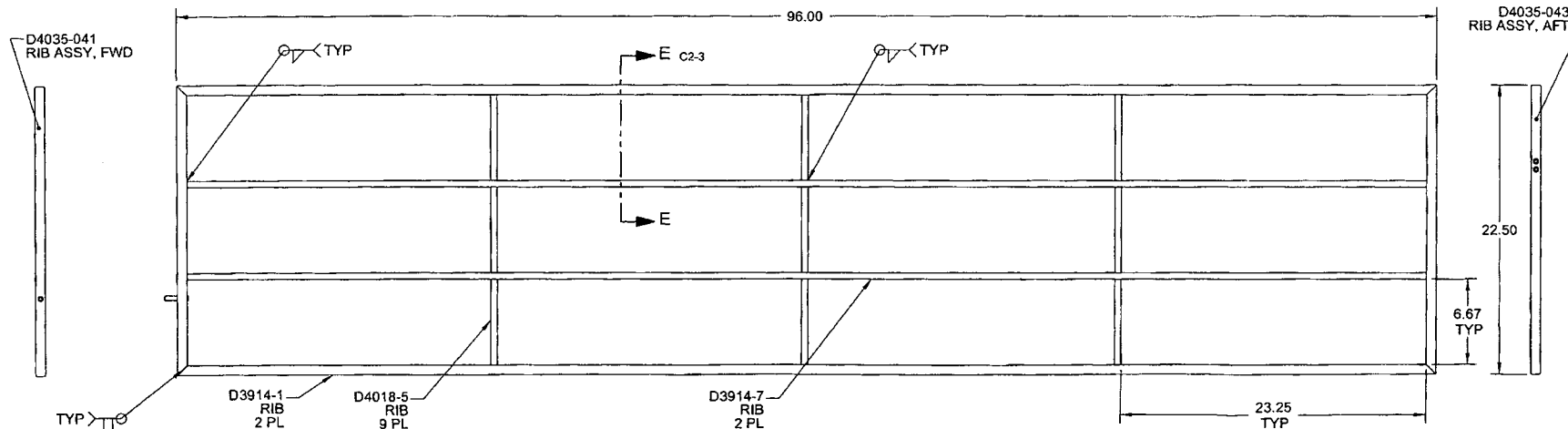
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E CS-3

#80775



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10-08-12 CP

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.10 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
 - 9) WELD PER DART QSI 004

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CHECKED	RC	DRAWING NO.	REV. B
MFG. APPR.	MS	D3914	SHEET 3 OF 4
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	LONG BASKET LID ASSY (350)	NTS
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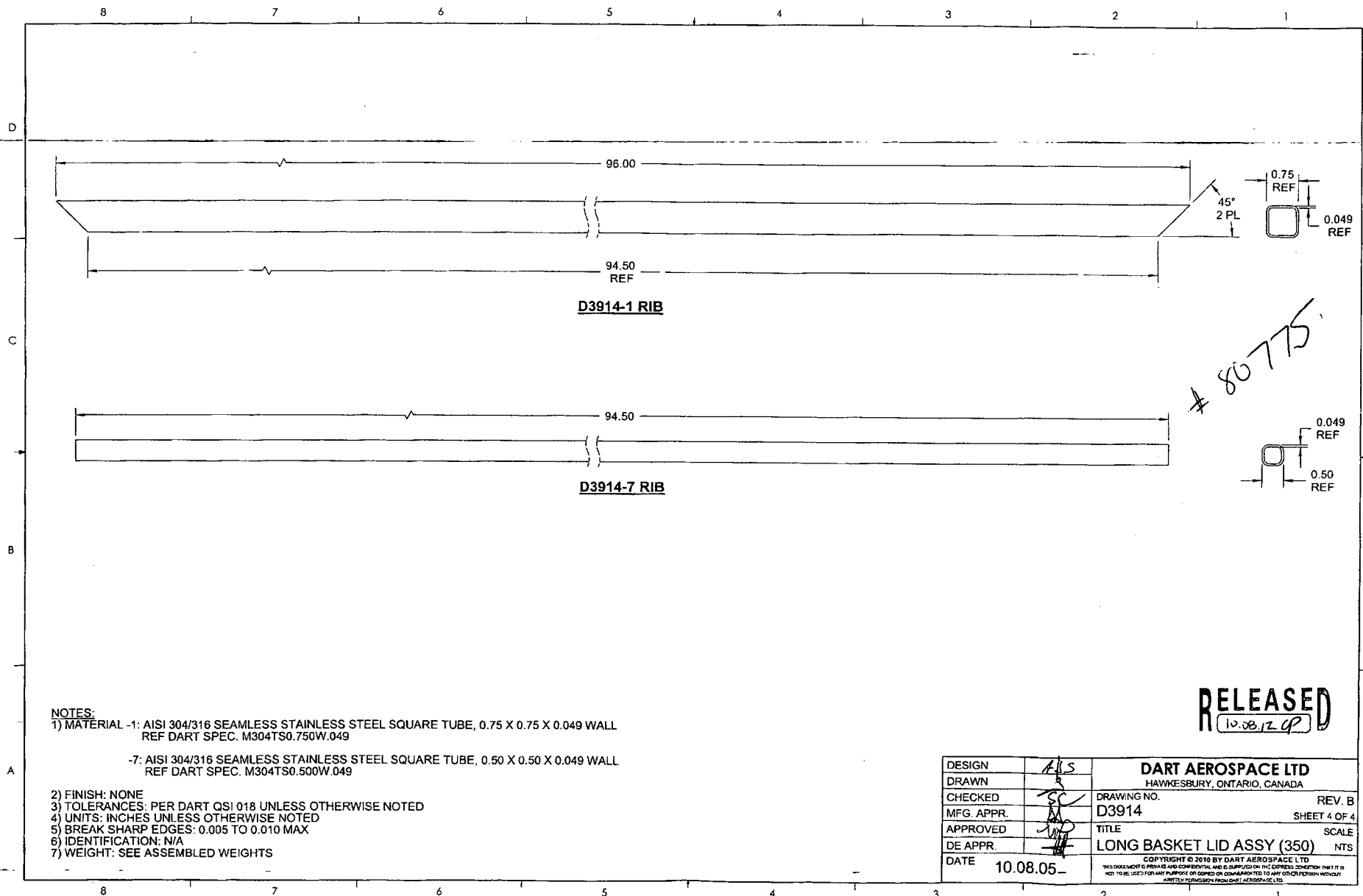
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